

Date: Thursday, 20/11/2008 3:35:00 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL ASSEMBLY
Job Number : 43613	
Estimate Number : 10504	
P.O. Number :	Part Number : D3204041
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 43446	Material :
Written By :	Due Date : 21/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>MO 08.11.21</u>	
Comment : Est:C 05.08.11 Added Step 25 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32041	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D3204-1	Tube	B38321

EL 9-1-21 x4

2.0	D32043	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-3	Arm	B43508

EL 9-1-21 x4

3.0	D32045	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-5	Arm	B43616

EL 9-1-21 x4

4.0	D32049	Pedal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pedal

Pick:

Qty	Part Number	Description	Batch
1	D3204-9	Pedal	B43618

EL 9-1-21 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:00 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43613

Part Number: D3204041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D320411	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3204-11	Plate	2-0835874 2-0 B43614

EL 9-1-21 x4

6.0	D320413	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

Batch: B43762

EL 9-1-21 x8:

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
 - 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
 - 3- Use JB weld compound to plug the hole after assembly.
 - 4- Grind JB weld flush after it is cured.
- Identify as D3204-041

(P70)

EL 9-2-5

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09-02-06 (1)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

809/02/06 (44)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 9-2-7 (4)

11.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

M 109648.

START TIME:

9:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3204-041 PAR #: N/A Fault Category: Prod Line Large NCR: (Yes) No DQA: D Date: 09/02/19
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 09/02/19

NCR: <u>43613</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09-01-21</u>	<u>7.0</u>	After welding Employee noticed that the D3204-3--5 were not square to each other. Part rocks. The part was not positioned correctly prior to welding. R.C. Human error.	<u>[Signature]</u>	remove & replace qty 1 of each. D3204-5 B <u>B43616</u> D3204-13 B <u>B43767</u> re-weld back into position.	<u>[Signature]</u> <u>9-2-6</u>	<u>[Signature]</u> <u>09/02/16</u>	<u>[Signature]</u> <u>09/02/16</u>	<u>[Signature]</u> <u>09-01-21</u>

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 43613

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°

FINISH TIME: 9:45

BR 09-02-12 (4)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/02/12 (4)

13.0

D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
2	D3204-7	Bushing

Batch

413617
B04720 x3

SS 09/02/12 (x4)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

EP 09/02/13 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-13 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 205

8/12/13

(4)

SP

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



MF
09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

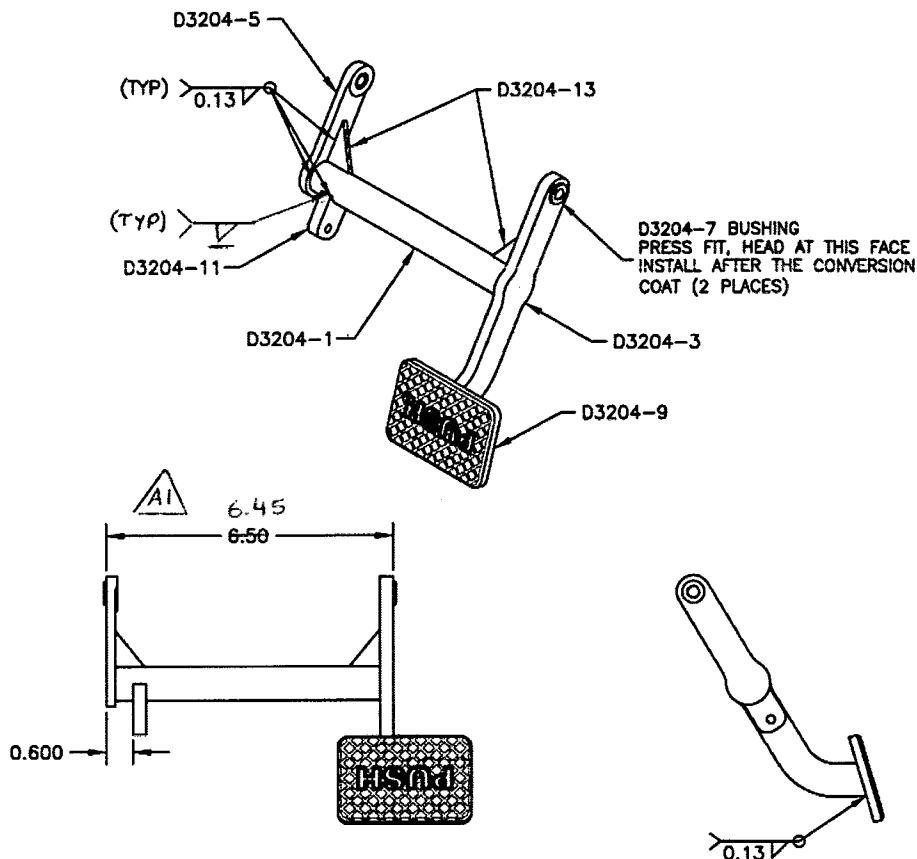
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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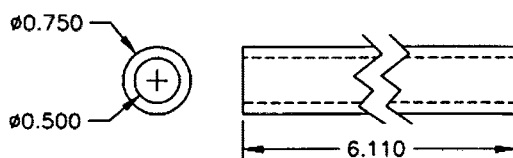
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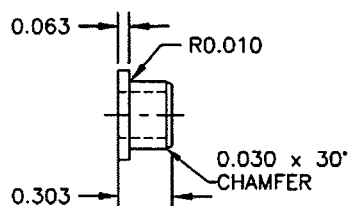


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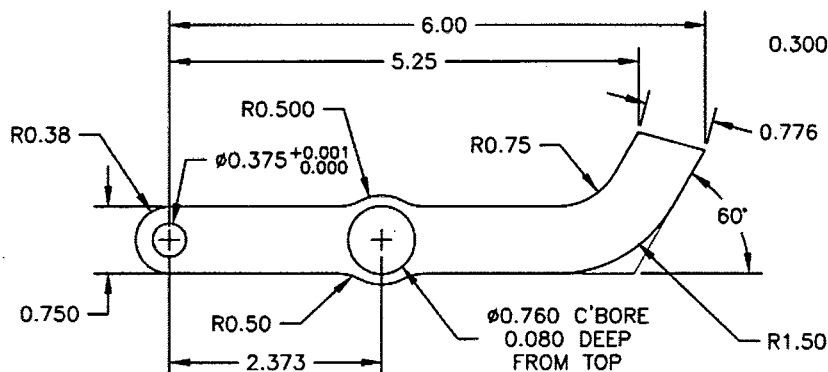
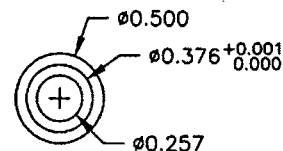
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04.04.05



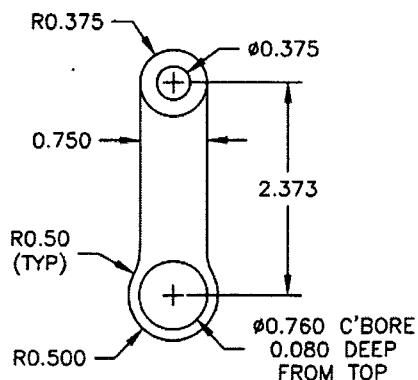
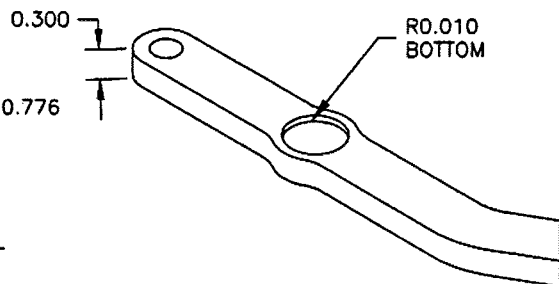
2 **D3204-1 TUBE**
SCALE 1:2



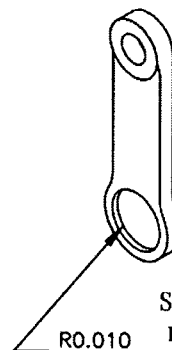
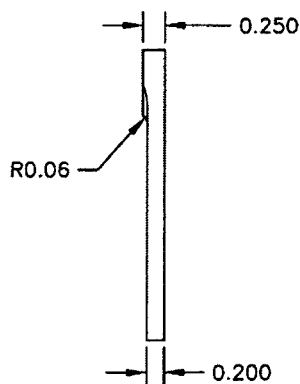
4 **D3204-7 BUSHING**
SCALE 1:1



3 **D3204-3 ARM**
SCALE 1:2



3 **D3204-5 ARM**
SCALE 1:2



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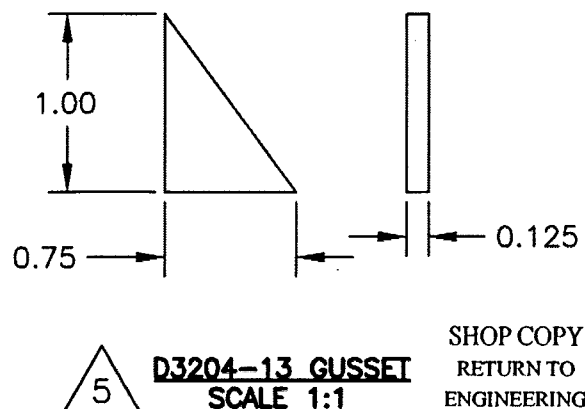
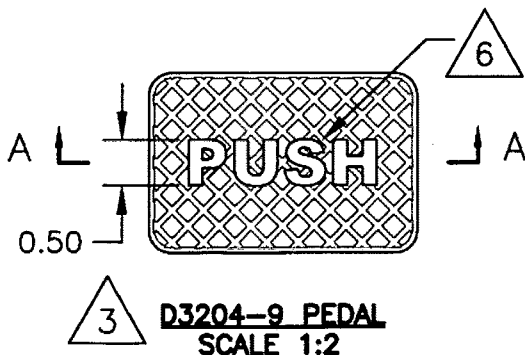
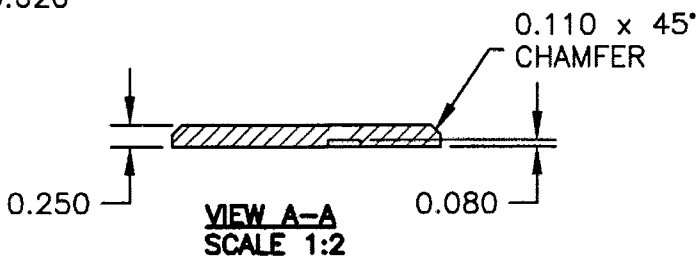
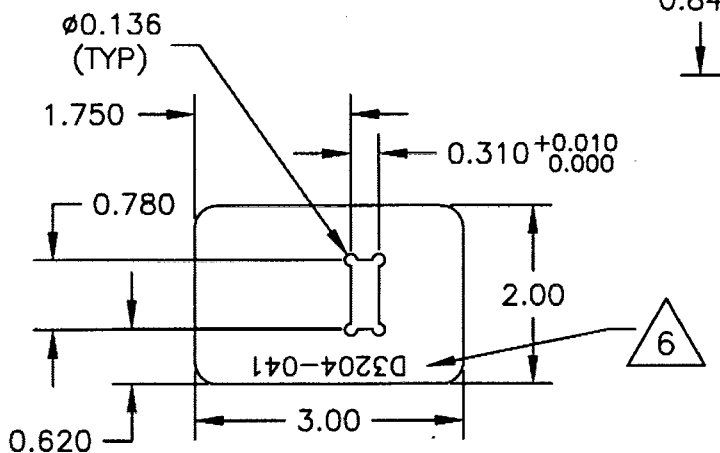
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.70



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